



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3573-8

Job Sheet 178834



Part No: D3573-8

Job Qty: 8 ea

Part Name: Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/8/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-01-29 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		6/15/18	0.00	0.00	Start Up Machining-2		MM
100	Bandsaw	8 pcs		6/15/18	0.00	0.10	Bandsaw1		MM
110	CNC Vertical Machining	8 pcs		6/15/18	0.21	2.87	HAAS1-4		MM
130	QC	8 pcs		6/15/18	0.00	0.00	QC8 Machining-2		MM
140	HandFinish	8 pcs		6/15/18	0.00	0.31	HandFinish1		MM
150	Powdercoat	8 pcs		6/15/18	0.00	0.25	Powdercoat3		MM
160	QC	8 pcs		6/15/18	0.00	0.00	QC3		MM
170	Packaging	8 pcs		6/15/18	0.00	0.00	Packaging3-1		MM
180	QC21-SA	8 Ea		6/15/18	0.00	0.00	QC21		MM

Part Op 100 - Cut blank 3.500" long

Descriptions: 110 - Machine as per Folio FA679 and Dwg D3573

150 - START TIME: 1.35 O.T. 300° FINISH: 8:05.

170 - LOCATION: GA

M13637D.

DAS
21
9:50

JUN 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X02.500	6061-T6 Bar .500 X 2.50	2.3360 ft (.292 ea)	90-Start up Operation	5033403

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.500X02.500	2	24	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Adapter	3.320Inches ± 0.030	3.350 3.290		
2	Adapter	2.750Inches ± 0.030	2.780 2.720		
3	Adapter	0.360Inches ± 0.030	0.390 0.330		
4	Adapter	1.600Inches ± 0.010	1.610 1.590		
5	Adapter	0.480Inches ± 0.030	0.510		

			0.450	
6	Adapter	2.380Inches ± 0.030	2.410 2.350	
7	Adapter	1.420Inches ± 0.010	1.430 1.410	
8	Adapter	1.813Inches ± 0.010	1.823 1.803	
9	Adapter	0.209Inches $+ 0.005$ $- 0.001$	0.214 0.208	Diameter
10	Adapter	0.201Inches $+ 0.005$ $- 0.001$	0.206 0.200	Diameter
11	Adapter	0.900Inches ± 0.010	0.910 0.890	Diameter
12	Adapter	0.500Inches ± 0.010	0.510 0.490	Diameter
13	Adapter	0.390Inches ± 0.010	0.400 0.380	
14	Adapter	0.385Inches ± 0.010	0.395 0.375	Diameter
15	Adapter	0.630Inches ± 0.030	0.660 0.600	Radius
16	Adapter	0.130Inches ± 0.030	0.160 0.100	Radius
17	Adapter	0.020Inches ± 0.030	0.050 (0.010)	Radius

DART
AEROSPACE

Container No: S083921



Part: D3573-8

Job No: 178834

Serial No/Batch: S083921

Revision:

Inspector:

Exp Date:

Instructions:

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Date: 06/25/18

Plex 6/8/18 8:04 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	178834
Description: Adapter		Part Number:	D3573-8
Inspection Dwg: D3573	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.32	+/-0.030	3.315	✓		Vernier	
2.75	+/-0.030	2.751	✓		high gage	
0.36	+/-0.030	.357	✓		Vernier	
1.600	+/-0.010	1.598	✓		Vernier	
0.48	+/-0.030	.477	✓		Vernier	
2.38	+/-0.030	2.375	✓		Vernier	
1.420	+/-0.010	1.418	✓		Vernier	
1.813	+/-0.010	1.815	✓		high gage	
Ø0.209	+0.005/-0.001	.210 Ø	✓		Pin gage	
Ø0.201	+0.005/-0.001	.200 Ø	✓		Pin gage	
Ø0.90 x 0.100	+/-0.010	.898 x .102	✓		Vernier	
Ø0.500 x 0.310	+/-0.010	.502 x .309	✓		Vernier	
0.390	+/-0.010	.397	✓		Vernier	
Ø0.385 x 100°	+/-0.010 x 0.5°	.395 x 100°	✓		Vernier	
R0.63	+/-0.030	R0.63 R.630	✓		Gaborit	
R0.13	+/-0.030	R.120	✓		↓	
R0.02	+/-0.030	R.020	✓			

Measured by:	M.M.	Audited by:	J.F.	Prototype Approval:	N/A
Date:	2018/06/25	Date:	18-06-26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	EF

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